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Bonding steel on steel***Important!***

These repair instructions apply to structural components.

Such components include engine supports, A-pillars, B-pillars, etc.

Follow the vehicle-specific repair instructions.

Only use the repair procedures described there.

Conform with [safety regulations](#)!

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Overview of topics:

1. Equipment
2. Preparing the surface
3. Bonding coat
4. Hardening times
5. Subsequent treatment

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1.0 Equipment

- Sandpaper
- [Cleaning agent R1](#)
- [Adhesive K1](#)
- [Cartridge gun](#)

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2.0 Preparing the surface:

- For better adhesion, remove oxide film and paint from the adhesive areas with a stainless steel wire

brush or special sandpaper.

- Clean bonding surfaces with cleaning agent R1.
- Allow cleaned surfaces to dry for approx. 5 minutes.

Bonding surfaces must be completely dry.

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3.0 Adhesive application:

- Processing temperature of glue cartridge 18 °C - 30 °C.
- Object temperature, vehicle and new parts, min. 15°C.
- After applying the adhesive, check whether an adhesive component has emerged at the back of the glue cartridge. If yes, break off the bonding procedure. Clean new part. Use new glue cartridge. Contact national hotline.
- Join components and secure in position.
- Remove excess adhesive. Do not use solvent cleaning agents.

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4.0 Hardening times:

- Refer to [Notes regarding adhesive K1](#)

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5.0 Subsequent treatment of bonding surfaces:

- Protect the repair area with cavity sealant.